

Date: Tuesday, 4/18/2006 10:06:40 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT	
Job Number	: 26685		Part Number	: D31691	
Estimate Number	: 11336		Drawing Number	: D3169 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/18/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/9/2006	
Previous Run	: 25200		Qty:	120 Um: Each	
Written By	: See Comment Below				
Checked & Approved By	: JF 06.04.18				
Comment	: Est Rev:A 02/10.17 New issue KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0625X02500	6061-T6 Bar .625" x 2.5"
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Comment: Qty.: 0.3360 f(s)/Unit Total : 10.0800 f(s)

Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8 or QQ-A-250/11) (M6061T6B0.625x02.500)

Batch: M13956

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 3.850" x 2.50" x 0.625" thick

J.F. 06/04/26 x 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA283 and Dwg D3169

2-Deburr & Tumble

J.F. 06/04/27 20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/04/27 20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/04/27 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:06:40 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 26685

Part Number: D31691

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST411	<i>SL 06/04/08 (20)</i>
7.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	<i>D 06/05/01</i> <i>6 06.05.01</i>

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26685
Description: Support	Part Number:	D3169-1
Inspection Dwg: D3169	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

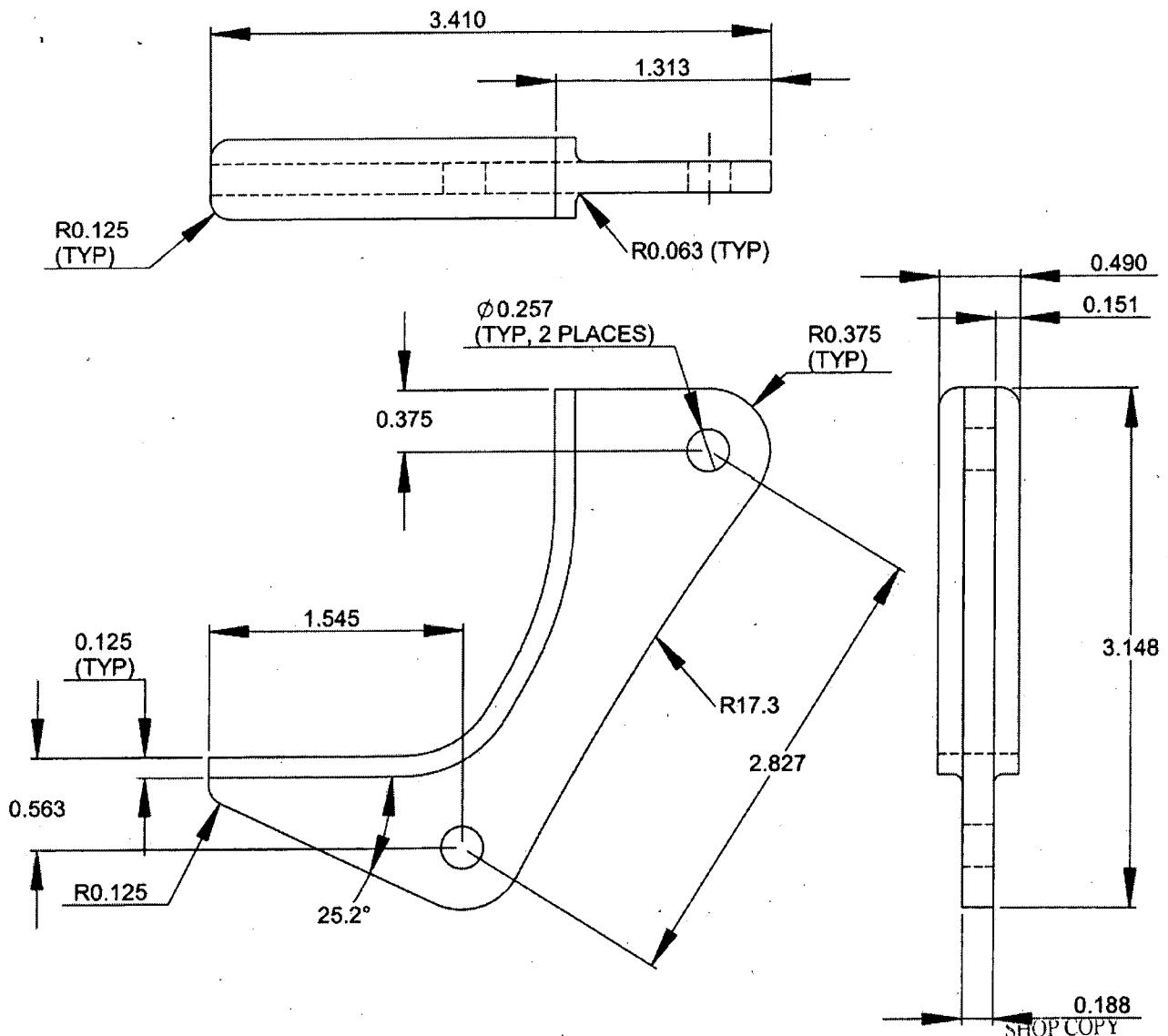
X First Article Prototype

Measured by:	J.F.	Audited by:	S.G.	Prototype Approval:	N/A
Date:	06/04/27	Date:	06/04/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	✓

DARTGACOPY'S
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3169	SHEET 1 OF 1
DATE	02.09.11	TITLE	SCALE
		SUPPORT	1:1
A	02.09.11	NEW ISSUE	

RELEASED
(02.09.2011)**D3169-1 SUPPORT**

- 1) MACHINE PER DWG FILE "D3169-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11)
(REF DART SPEC M6061T6B OR M6061T6S)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 6) ALL DIMENSIONS ARE IN INCHES

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26685

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